

Work Order ID 55744

January 29, 2010 8:28:55 AM



Page 1

Item ID: D2498

Accept



Setup Start



Revision ID:

Stop



Item Name: Mounting Bracket, 205 Basket

Start Date: 1/28/10 Start Qty: 10.00



Cust Item ID:

Required Date: 2/08/10 Req'd Qty: 10.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

[Signature]

Date: 10-1-29

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2498

Rev B

100

0.00



BAND SAW

Bandsaw

Memo

0.00

aml 10/01/31

10

[Signature]

Jeaspa Bandsaw

Cut blanks: 8.500" x 4.000"

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

aml 10/02/01

10

[Signature]

HAAS CNC vertical machine #1

Machine as per folio D2498 Deburr

SP 10/02/03

[Signature]

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

aml 10/02/01

10

[Signature]

Quality Control

SP 10/02/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2498 PAR #: _____ Fault Category: Machined parts NCR: Yes No DQA: 7 Date: 10/03/02
 Resolution: Accepted Disposition: Use as is QA: N/C Closed: _____ Date: _____

NCR: <u>55744</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/02/03	110	Dimension of .250 ⁺ .010 ⁻ was .002" under to be .238" R.C. operator on shift tool is origin wrong on first parts. L.O.A. Lack of attention.	<p>CP</p> <p>10.02.03 PC</p> <p>Q51042</p>	<p>21M Ø HOLES IN TOL. 0.238 ONLY AT TIP. ACCEPTABLE.</p>	<p>CP</p> <p>10/02/03</p>	<p>QML</p> <p>10/02/04</p>	<p>CP</p> <p>10.02.03 PC</p> <p>Q51042</p>	<p>5</p> <p>10/02/04</p>

NOTE: Date & initial all entries

Work Order ID 55744

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Page 2

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Start Date: 1/28/10 Start Qty: 10.00



Cust Item ID:

Required Date: 2/08/10 Req'd Qty: 10.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	QC8- Inspect parts - second check	0.00							
QC Quality Control	Memo	0.00	M.A	10/02/04		10	0		
140 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish Hand Finishing	Memo	0.00	BR	10.02.5		10	0		
150 	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat Powder Coating	Memo *****mask slot as per dwg***** START TIME: 2:45 PM OVEN TEMPERATURE: 315 F TIME: 320 F	0.00	2)	M	10/02/08	10	0		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55744

January 29, 2010 8:28:55 AM



Page 3

Item ID: D2498

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Setup Start



Revision ID:

Stop



Item Name: Mounting Bracket, 205 Basket

Start Date: 1/28/10 Start Qty: 10.00



Cust Item ID:

Required Date: 2/08/10 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

BK 12-02-9

(1P)

φ

Memo

0.00

170



Packaging

Packaging

Identify as per dwg & Stock Location: 513

0.00

0.00

Memo

PC 10/2/11 (10)

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

10/02/18 J

ME 10-2-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 29, 2010 8:29:00 AM

Page 1

Work Order ID: 55744



Parent Item: D2498

Parent Item Name: Mounting Bracket, 205 Basket

Start Date: 1/28/10

Required Date: 2/08/10

Comments: IPP A 02.06.06 New Issue NG

Start Qty: 10.00

Required Qty: 10.00

IPP B Rev B dwg 07-09-25 DD verified by EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B1.000X04.00 0		Purchased	No			100	f	68.5000	18.4916			



6061-T6 Bar 1.00 x 4.00



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

68.5

107221

62.27

→ 11941

6.23

3.115 ml 10/01/31

M 88 03 0.708' - ?

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	55744
Description: Mount		Part Number:	D2498
Inspection Dwg: D2498 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.375	+/-0.010	.373	✓			
0.625	+/-0.010	.624	✓			
1.419	+/-0.010	1.419	✓			
1.875	+/-0.010	1.870	✓			
2.469	+/-0.010	2.469	✓			
3.375	+/-0.010	3.370	✓			
0.375	+/-0.010	.373	✓			
0.875	+/-0.010	.878	✓			
1.500	+/-0.010	1.500	✓			
3.150	+/-0.010	3.150	✓			
3.775	+/-0.010	3.771	✓			
4.825	+/-0.010	4.825	✓			
0.500	+/-0.010	.498	✓			
5.325	+/-0.010	5.323	✓			
0.115	+/-0.010	.119	✓			
1.000	+/-0.010	1.003	✓			
0.770	+/-0.010	.764	✓			
0.20	+/-0.010	.200	✓			
0.40	+/-0.010	.400	✓			
0.250	+/-0.010	.257	✓			
0.500	+/-0.010	.502	✓			
R0.50	+/-0.010	R.500	✓			
R.38 R0.58	+/-0.010	R.385	✓			
0.25	+/-0.010	.245	✓			
R0.25	+/-0.010	R.250	✓			
R0.25	+/-0.010	R.250	✓			
R0.13	+/-0.010	R.125	✓			
Ø0.257	+0.006/-0.001	Ø.259	✓			
Ø0.316	+0.006/-0.001	Ø.318	✓			

Measured by:	SM	Audited by:	NA	Prototype Approval:	N/A
Date:	10/02/01	Date:	10/02/04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.11	New Issue	KJ/DD	

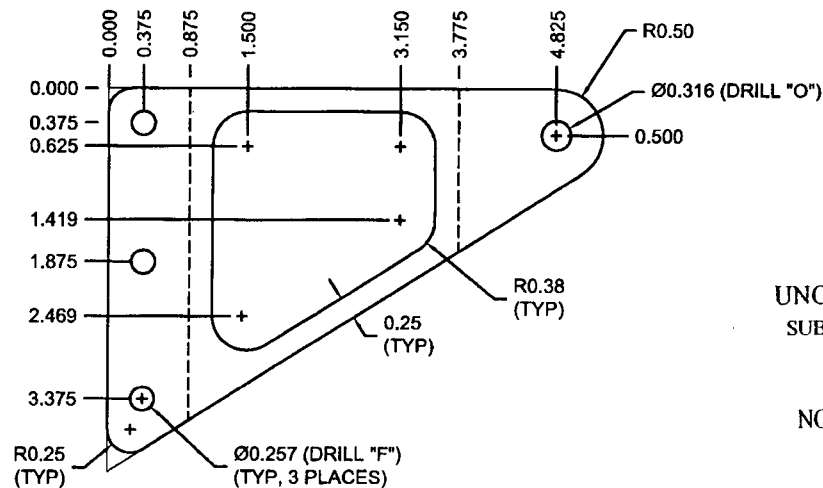
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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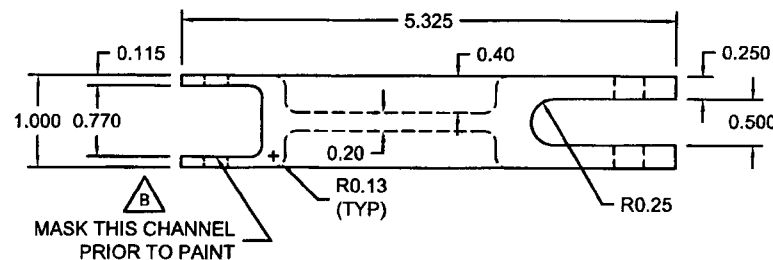
NOTE: Date & initial all entries



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 55744
B/10-1-20

RELEASED

07.08.29



D2498 MOUNT

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2498" USING FINE POINT
PERMANENT INK MARKER
- 7) WEIGHT: 0.57 lbs

B	- ADDED MASKING DETAIL - DUE TO TIGHT FIT WHEN INSTALLED ON BASKET - ADD MASKING STEP TO ESTIMATE	DC	07.07.25
A	NEW ISSUE	KH	95.11.09
REV.	DESCRIPTION	BY	DATE
DESIGN	B WILLIAMS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D2498	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MOUNT	1:2
DATE	07.07.25	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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